

Date: Wednesday, 26/11/2008 12:45:42 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR BODY
Job Number : 43741	
Estimate Number : 11975	
P.O. Number :	Part Number : D2094
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D2094 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30153	Material :
Written By :	Due Date : 10/12/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 08.11.26</u>	
Comment : Est. B 99.01.20 Re-format DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2061	Aspirator
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Aspirator

Pick:

Qty Part number Description Batch

1 D2061 Aspirator Body

43502

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1 Drill 4 flange holes as per Dwg D2092/93/94 using Drill Jig DT 8262

FF 09/02/05

2 Cut edges as per Dwg D2095 using Jig DT 8263

3 Drill 5/16 hole for jet as per Dwg D2092/93/94 using Drill Jig DT 8296

FF 09/02/06

4 Deburr

m-d

09/02/05

(20x)

5 Clean and polish with water and thinner

FF 09/02/06

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/02/06 (420)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2094 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: R Date: 05/02/12
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>43741</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/10	# 2.3	During inspection found 3 parts with 0.3125" (5/16") hole too large. R.C. drill wanders when drilling * Lack of care.	<i>[Signature]</i> 05/02/12	Acceptable deviation this time only. Will be corrected upon welding the assy. Ensure to take more care & more attention when drilling	<i>FF</i> 09/02/11	<i>[Signature]</i> 05/02/12	<i>[Signature]</i> 05/02/12	<i>[Signature]</i> 09-02-10

NOTE: Date & initial all entries

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Drawing Name: ASPIRATOR BODY

Job Number: 43741

Part Number: D2094

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST171

JS 09/02/11 (x20)

5.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/12 *JS*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

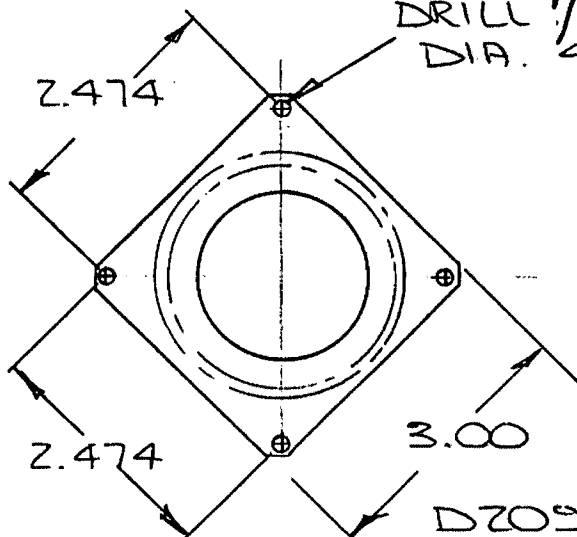
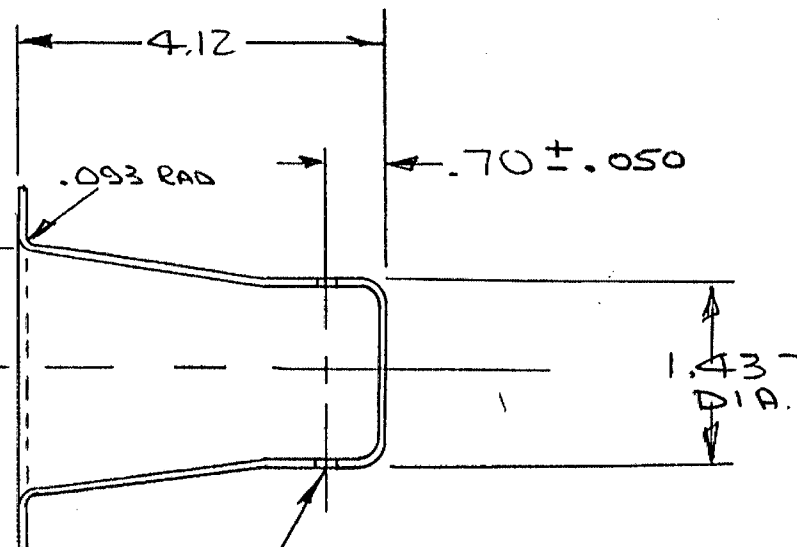
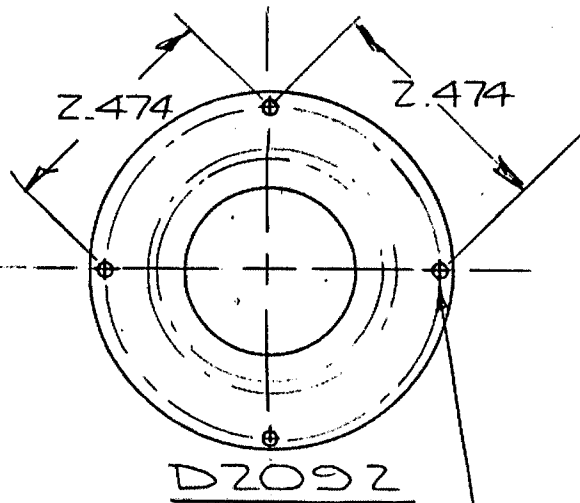
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
2009/3/4
KIVA.



DRILL $\frac{1}{4}$ (.250)
DIA. 4 HOLES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4394

DRILL $\frac{5}{16}$ (.312) DIA THRU
AS SHOWN ON D2092
AND D2093. ROTATE 45°
ON D2094.

MATERIAL: 1100-O, .063
SPIN FROM
SHEET STOCK

A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 823		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR	
	DRAWN		BASIC CODE	DIA. DASH NO. H=HEAD NEAR SIDE F=HEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. CANADA			
	APPROVED		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED	D=DIMPLE DASH=NO OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN	DATE	DART AERO ACCESSORIES INC. CANADA		
	DESCRIPTION OF CHANGE		GENERAL	LIMITS	BASIC CODES	DESIGN	DATE	DART AERO ACCESSORIES INC. CANADA		
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5 - 32 5. HOLES PER AND 10387	1. TOLERANCES — .005 2. ANGLES — 5° 3. PARALLELISM — .0025 4. ECCENTRICITY — .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	B=M52047DAD BB=M52047BAD	STRESS		TITLE	D2092/93/94		
REPORT ALL DISCREPANCIES — DO NOT SCALE					CHECKED		CODE	DWG NO.	REV.	
					CLIENT		SCALE	1:2	SHEET 1 OF 1	

D2092/3/4

A

COPY 150

2 1